

Work Order ID 134105

Tuesday, June 30, 2015 1:53:46 PM

134105

Page 1

Item ID: D3272-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step

Start Date: 6/30/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/30/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: *MLS*

Date: **JUN 30 2015**

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

0.00

100

100

Large Fab

0.02

Large Fab

Memo

Large Fab

SQUARE ONE END BEFORE CUTTING OTHER END

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

3-Deburr

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

4X 0215/7/2

4

JUL 02 2015

**DAS
24
9-89**

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Item ID: D3272-1

Revision ID:

Item Name: Step

Start Date: 6/30/2015 Start Qty: 4.00

Required Date: 6/30/2015 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

QC:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

NR1***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

120

Identify as per dwg & Stock Location: *W/A*

0.00

120

Packaging

Memo

0.00

Packaging

LOCATION: WA003

4x 26 15-7-2

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.01

Quality Control

*MLJ JUL 03 2015**MLJ JUL 02 2015*

Picklist Print

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Page 1

Work Order ID: 134105

134105

Parent Item: D3272-1

D3272-1

Parent Item Name: Step

Start Date: 6/30/2015

Required Date: 6/30/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-06-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2622-120C

Manufactured

No

100

Each

96.9200

1

4

D2622-120C

**

Step Extrusion

4X Dk 15/7/2

Location

Loc Qty

Loc Code

WA003

96.92

125381

3.92

130161

93

4



DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

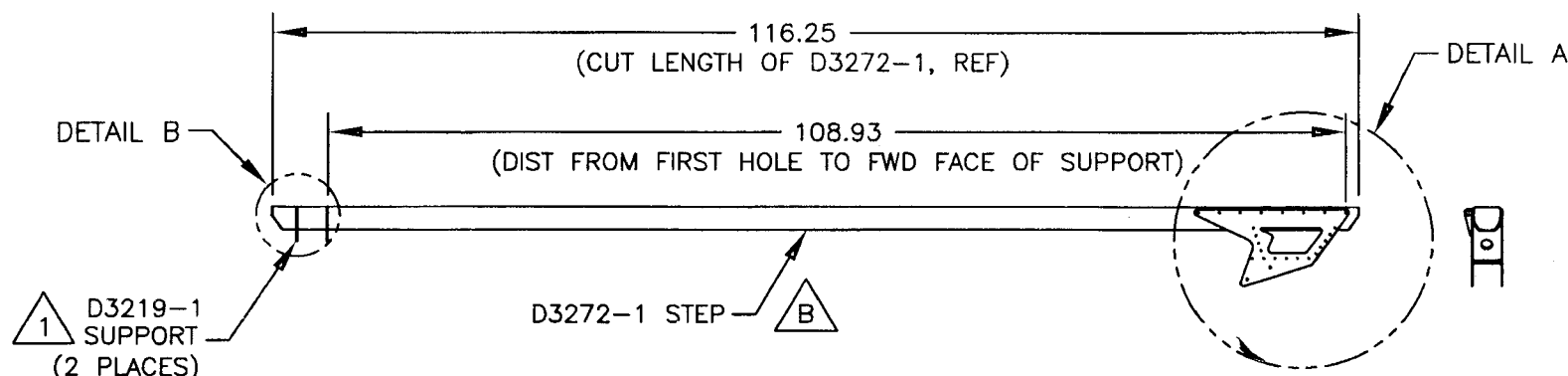
NO. 134105 MCT
1506-30
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SHOP COPY
WITHOUT NOTICE
SUBJECT TO AMENDMENT
WORK ORDER

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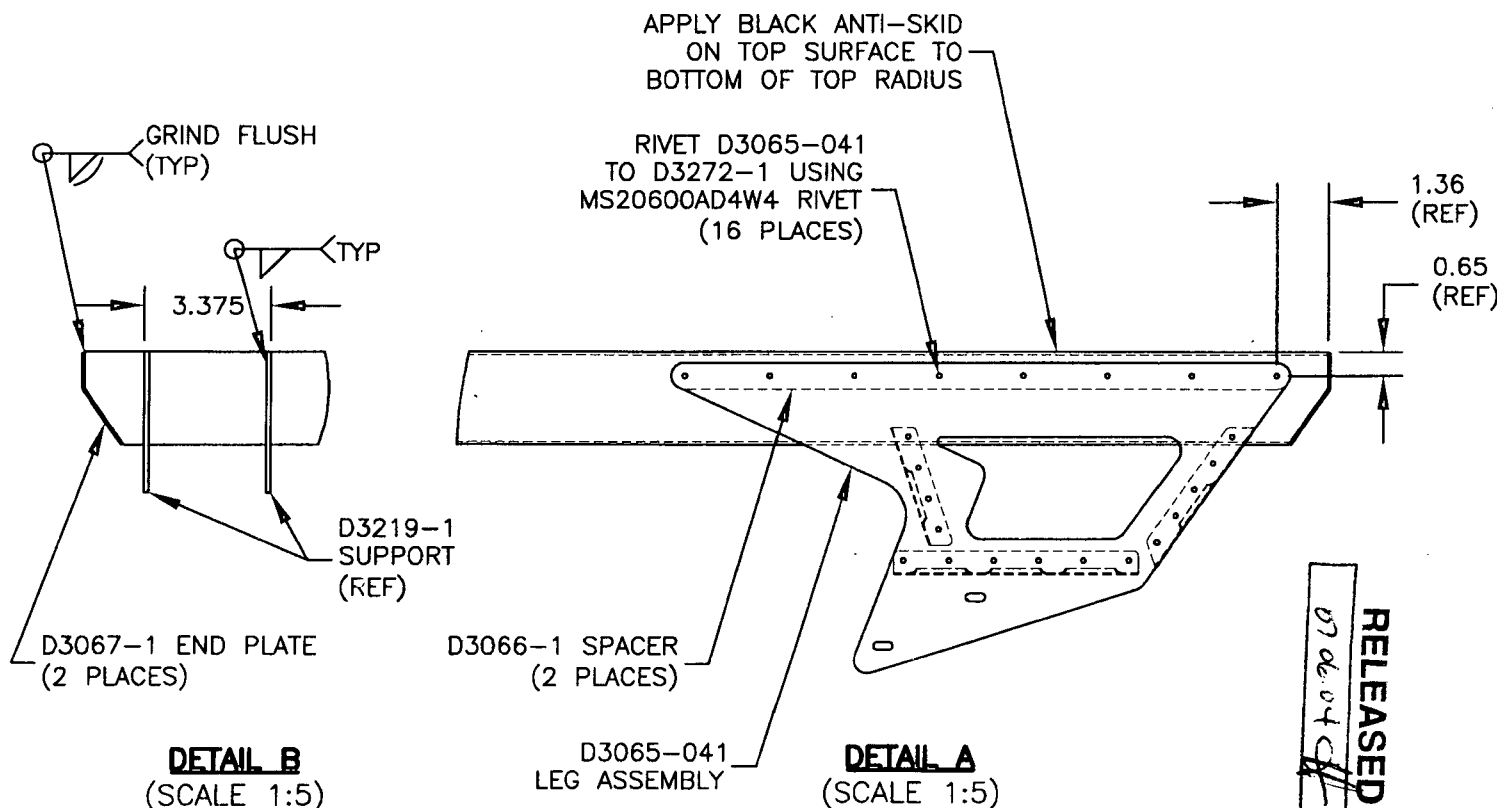
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DART

DESIGN	90	DRAWN BY	JS	DART AEROSPACE LTD
CHECKED	Le	APPROVED	JS	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE	1:20	



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

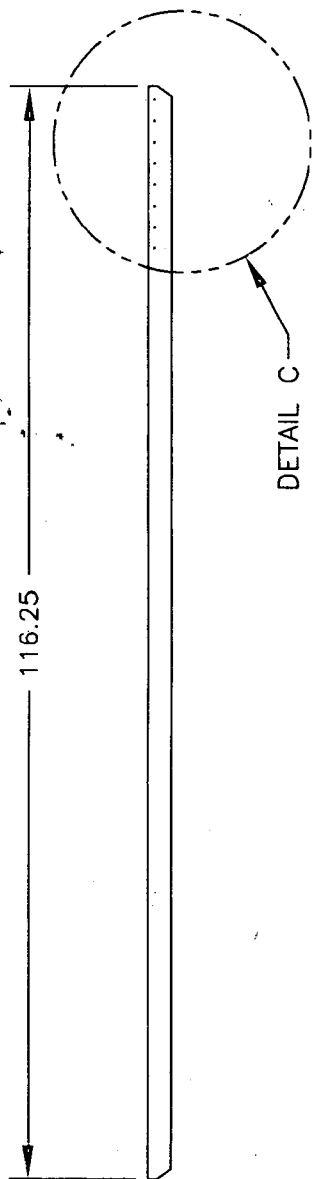




DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20

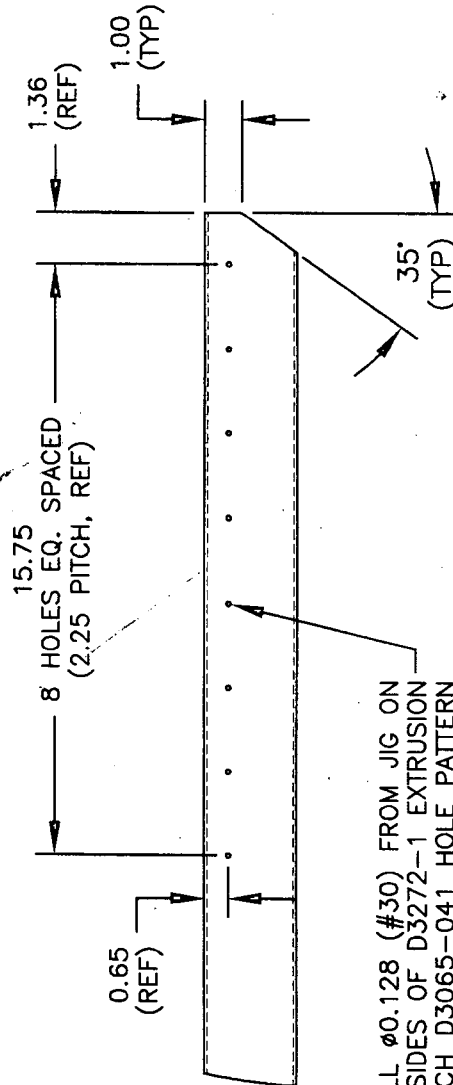
RELEASED

07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

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